












Date: Monday, 6/19/2006 11:30:43 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WASHER
Job Number	: 27644		
Estimate Number	: 11218		
P.O. Number	: <u>NIA</u>	Part Number	: D34173
This Issue	: 6/19/2006 S.O. No. : <u>NIA</u>	Drawing Number	: D3417 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>NIA</u> Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 27571	Material	: <u>NIA</u>
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 7/15/2006
Checked & Approved By	: <u>06.06.19</u>	Qty:	<u>30</u> Um: Each
Comment	: Est Rev:A 05.10.19 New issue KJ/EC Est Rev:B 05.10.19 added haas op. EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	MDELNR12500	DELRIN ROUND BAR 1.25"	
			
Comment: Qty.: 0.0311 f(s)/Unit Total: 0.6216 f(s) Material: Delrin Round Bar Ø1.250 (M-DELRIN-R1.250) Batch: <u>M101018 15"</u> Identify for D3417-3			
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
			
Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Folio FA594 Rev: <u>C</u> & Dwg D3417 Rev: <u>C</u> 2-Deburr			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
Comment: HAAS CNC VERTICAL MACHINING #1 -Machine as per folio FA594 rev. <u>C</u> & dwg D3417 rev. <u>C</u>			
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 2 Date: 02/06/29

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WASHER

Job Number: 27644

Part Number: D34173

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 06.06.27

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

06/06/28 (30)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/29 (30)

Job Completion



U 26.06.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

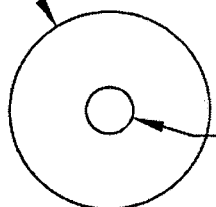
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3417	REV. C SHEET 1 OF 1
DATE 05.06.30		TITLE WASHER	SCALE 1:1
A	05.03.31	NEW ISSUE	
B	05.06.10	CHANGE TO ROUND WASHER	
C	05.06.30	REMOVE C'BORE, WIDEN	

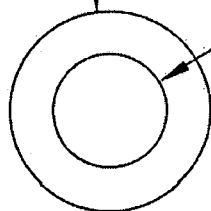
RELEASED05.11.14 *[Signature]* $\varnothing 1.125^{+0.030}_{-0.000}$  $\varnothing 0.265^{+0.005}_{-0.000}$

R1.87

0.409



0.320

 $\varnothing 1.125^{+0.030}_{-0.000}$  $\varnothing 0.640^{+0.005}_{-0.000}$

R1.87

0.346



0.260

**D3417-1 WASHER****D3417-3 WASHER****D3417-1/-3 WASHER**

- 1) MATERIAL: DELRIN (REF. DART SPEC. M-DELRIN-R1.250)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. *27644*

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